

Work Order ID 69626

Thursday, May 12, 2011 3:18:19 PM



Page 1

Item ID: D3205-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Plate

Start Date: 5/12/2011

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3205	Rev A								

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jespa Bandsaw

Cut blanks: 2.00" x 0.250" x 2.480" long Bar (+0.030/-0.000)

6061

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Machine D3205-3 as per Folio PA343 and Dwg D3205 Identify as D3205-3
3 Debur and Tumble

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-6-1

(21)

B11-6-1

B11-6-1

Water Jet (This Batch only.)
N/A
Jespa 11-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69626

Thursday, May 12, 2011 3:18:19 PM



Page 2

Item ID: D3205-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Plate

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 1106102

count
(x21)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

21x Ø M/11/06/02

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

10:00

10:30

3200K

21x Ø M/11/06/03

M115128

W/O:		WORK ORDER CHANGES					
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Thursday, May 12, 2011 3:18:19 PM

Page 3

Item ID: D3205-3

Accept

Revision ID:

Item Name: Back Plate

Start Date: 5/12/2011 Start Qty: 6.00

Required Date: 5/16/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

21 0 20 400/02

170



Packaging

Packaging

Identify as per dwg & Stock Location: GA

Memo

0.00

0.00

95/06/03 (20)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/06/03
ME

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:18:25 PM

Page 1

Work Order ID: 69626



Parent Item: D3205-3



Parent Item Name: Back Plate

Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B05.01.31 Revised Step 10 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.00 0		Purchased	No			100	f	54.5000	0.2175	1.373684	6		



6061-T6 Bar .250 X 2.00



Bill-61

Location

Loc Qty

Loc Code

MAT001

54.5

107436

54.5

107436

(21)

W/O:		WORK ORDER CHANGES					
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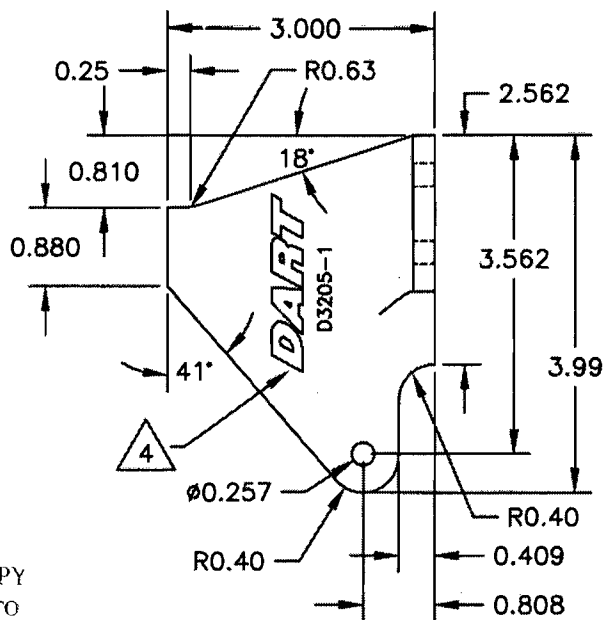
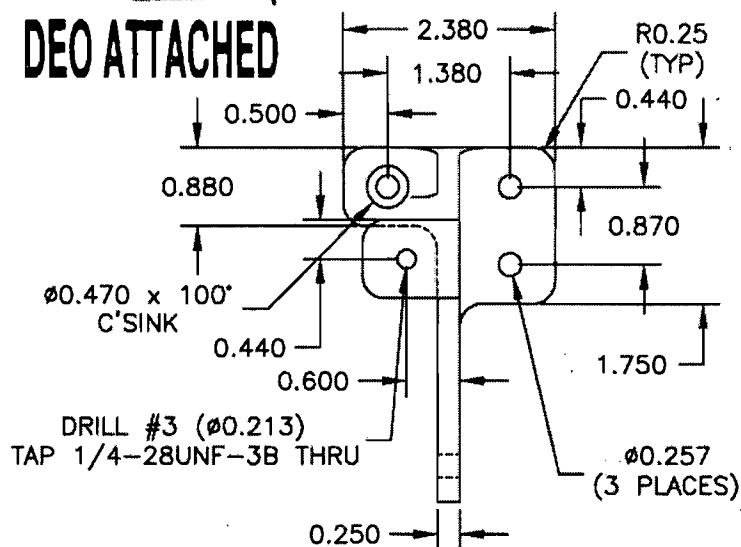
NOTE: Date & initial all entries



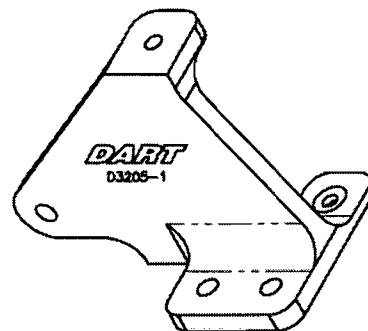
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05

DEO ATTACHED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09624



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

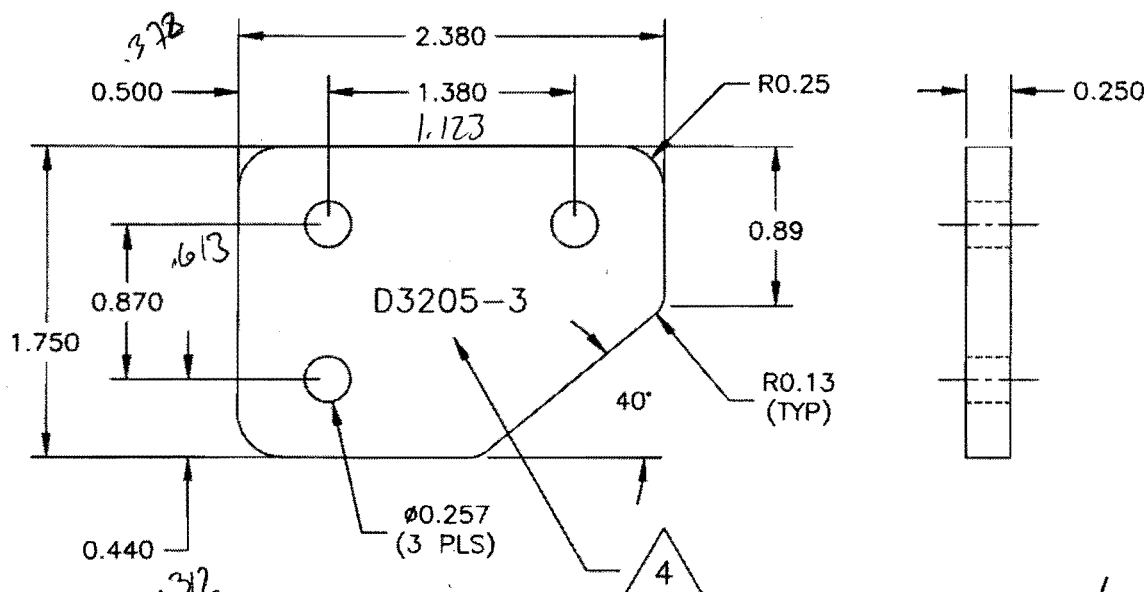
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
11	11	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
11	11	D3205
DATE	TITLE	REV. A
04.01.27	BRACKET	SHEET 2 OF 2
		SCALE 1:1

RELEASED
04.04.05
DEO ATTACHED



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

WATERJET
NO
ENGRAVING
11/06/01

21669624

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

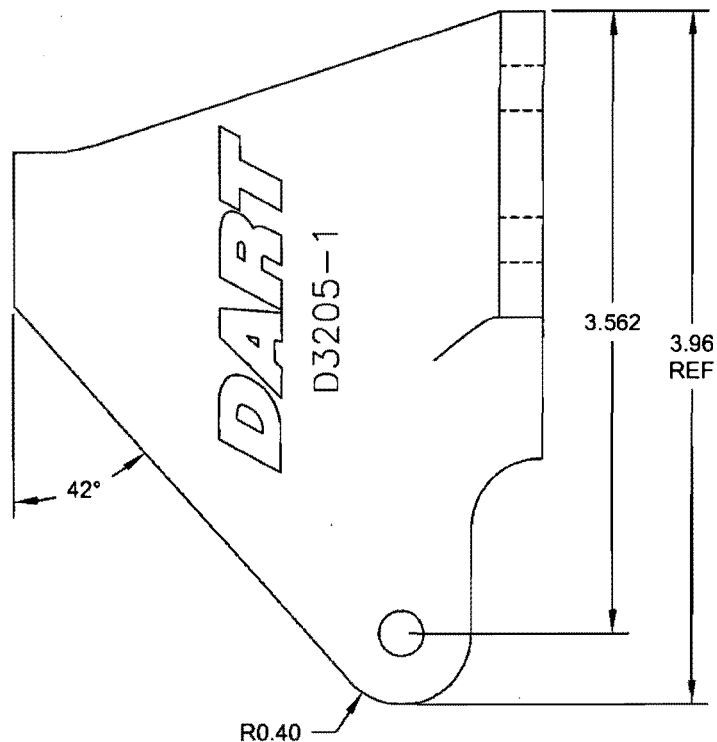
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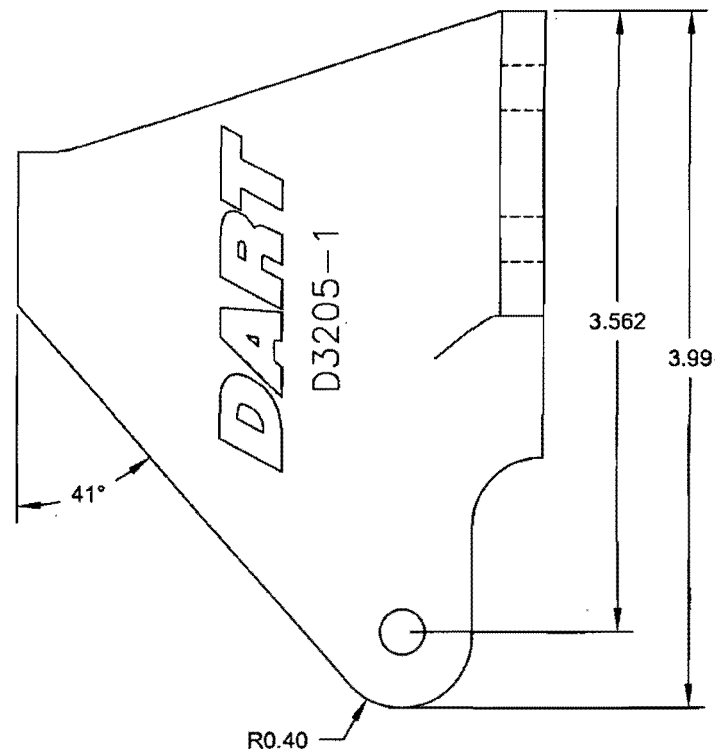
DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01		

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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